



Technical Bulletin

K-Line[®]

Subject: Guideliner Broaching Process and Tooling

Understanding why problems with the Guideliner occur after having used the product for years without any problems is mainly due to worn tooling.

The installation process of K-Line Guide Liners is a simple and fast process. Great care needs to be given to the tooling used in the broaching process.

NOTE: The ball broach is a hard chromed precision tool that serves two purposes:

- 1. Expands the liner wall to the desired size.**
- 2. Locks the liner in the existing guide.**

Given the fact that the ball broach is hard chromed, this does not take away the potential, that with time, it will wear and lose its chrome plating.

When the chrome plating shows signs of wear, the broach needs to be replaced ***immediately!***

By not doing so, the worn broach will cause the liner to push out of the guide during the broaching process. The worn broach can also scratch the ID of the bronze liner turning it into an abrasive surface that can, in some cases, cause premature valve stem wear.

CONTINUED NEXT PAGE



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This picture shows severely worn broaches. The Bronze color on the sizing sphere of the broach is Liner material embedded in the surface. This tool will cause a lot of damage to the liner.

NOTE:

It is recommended to lightly oil the broach before starting the broaching process. The Recommended Bronze-Lube part # KL1224 is ideal for this purpose and will extend the life of your broach and is available ONLY at the Nashville Warehouse. To order, please call 1-800-843-7328.